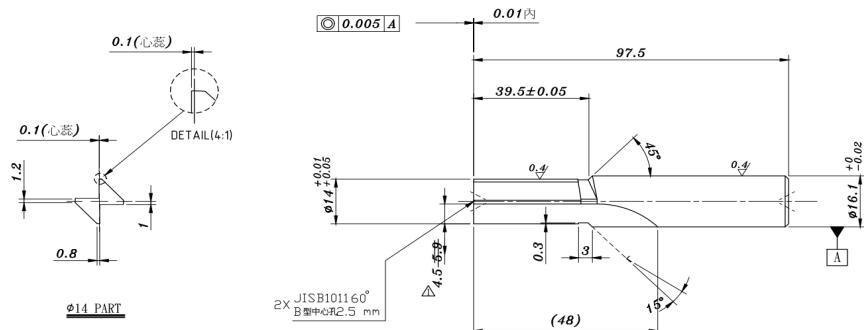


## Stepreamer Ø14-Ø16

### A15-200

This tool is basically not a finished tool, it is the shank before soldering of PKD inserts. The OD grinding was done before on a cylindrical grinding machine.



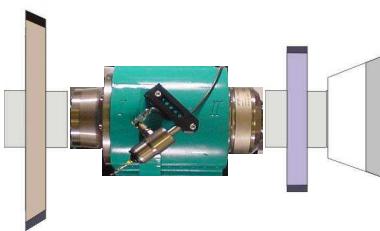
### 1. Cycletime for Production

Workpiece:	end-Ø14, shank-Ø16.1 mm, Z 2, Length 48 mm, Helix angle 0° Material CARBIDE					
Operations	Probe	Flute 1	Flute 2	O.D.2	O.D.1	Special Step
Feed [mm/Min]	2000	30	200	30	60	60
Power [kW]		2	1	1	1	1
Cutting speed [m/s]		20	20	22	22	22
Used wheels		1	1	2	3	3
Grinding time [s]	9	217	37	159	85	377
Total cycle time	14 Min 43					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1A1 Ø100 D76
2	11V9 Ø100 D76
3	1V1 Ø125 D76



3

1 2

### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories:

Responsible engineer: OP. 28.2.13

[www.schneeburger.ch](http://www.schneeburger.ch)

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland  
Subsidiaries in: France, Deutschland, Italia, United States, UK, China